

CLAIMS:

1. A sheet-shaped molded laminate including at least one of a concave portion and a convex portion, comprising:
a laminated skin member including a sheet-shaped lamination structure and a decorative face; and
a resin base material integrally injection molded on a face of the laminated skin member placed on an opposite side to the decorative face of the laminated skin member;
the laminated skin member including a sheet-shaped foamed layer with a density equal to or greater than 0.04g/cm^3 , a sheet-shaped decorative skin member bonded to one face of the foamed layer and including the decorative face, and a sheet-shaped backing layer bonded to the other face of the foamed layer; wherein before the laminated skin member and the resin base material are integrally molded, an elastic modulus of the laminated skin member in a warping deformation preventive direction of the molded laminate is equal to or smaller than $196\text{N}/25\text{mm}$ (width of a test piece of the laminated skin member: 25mm) with the laminated skin member being stretched by 33%.

2. A molded laminate according to claim 1, wherein the laminated skin member has an anisotropy in the elastic modulus thereof before the laminated skin member and the resin base material are integrally molded, and the elastic modulus of the laminated skin member in the warping deformation preventive direction of the molded laminate is

set lower than an elastic modulus of the laminated skin member in a crossing direction to the warping deformation preventive direction.

3. A molded laminate according to claim 2, wherein a density of the backing layer is set equal to or greater than 100g/m^2 .

4. A molded laminate according to claim 3, wherein the molded laminate is used for an interior equipment.

5. A producing method of a molded laminate including at least one of a concave portion and a convex portion, comprising:
a first step for preparing a laminated skin member including a lamination structure formed by a sheet-shaped foamed layer, a sheet-shaped decorative skin member bonded to one face of the foamed layer and including a decorative face, and a sheet-shaped backing layer bonded to the other face of the foamed layer;
a second step for setting the laminated skin member in a cavity of an injection mold having a concave portion or a convex portion; and
a third step for molding a resin base material on the backing layer side of the laminated skin member by injection molding of a resin in the cavity and at the same time, integrally bonding the backing layer of the laminated skin member and the resin base material, wherein the foamed layer is set with a density equal to or greater than 0.04g/cm^3 in the first step and an elastic modulus of the laminated skin member in a warping deformation preventive direction of the molded lamination in the first step

is set equal to or smaller than 196N/25mm (width of a test piece of the laminated skin member: 25mm) with the laminated skin member being stretched by 33%.

6. A producing method of a molded laminate according to claim 5, wherein in the first step, the laminated skin member has an anisotropy in the elastic modulus thereof, and the elastic modulus of the laminated skin member in the warping deformation preventive direction of the molded laminate is set lower than an elastic modulus of the laminated skin member in a crossing direction to the warping deformation preventive direction.

7. A producing method of a molded laminate according to claim 6, wherein in the first step, the laminated skin member is supplied from a roll member being wound into a roll shape, and set in the cavity in the second step such that the warping deformation preventive direction of the molded laminate corresponds to a crosswise direction of the roll member under a condition that a winding direction of the roll member is defined as a lengthwise direction thereof and a crossing direction to the winding direction of the roll member is defined as the crosswise direction thereof.

8. A molded laminate according to claim 3, wherein the density of the backing layer is between 100g/m² and 160g/m².

9. A molded laminate according to claim 5, wherein the density of the formed layer is between 0.057 g/m^3 and 0.063 g/m^3 .

10. A molded laminate according to claim 5, wherein when the resin of the resin base material is injection molded on the backing layer side of the laminated skin member, the molded resin penetrates through the backing layer thereby forming a penetrating portion between the backing layer and the resin base material.

11. A molded laminate according to claim 6, wherein the molded laminate after injection molded is heated by infrared rays.